

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026734**Date Inspected:** 18-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Boom**Summary of Items Observed:**

his Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations on this date were:

**Pier 7 Tower Boom Component: Outrigger Beam West #2**

This QA Inspector randomly observed ABF welder Mr. Jason Collins (Welder ID 8128) performing the fillet weld operation on the stainless steel plate A240 316L plate to A709 Grade 345 of Outrigger Beam West #2 per the Shielded Metal Arc Welding (SMAW) process in the (2F) horizontal position. This QA Inspector observed QC Inspector Mr. Bernie Docena verify prior to the start of the fillet weld operation that the welding parameters (Amps, Volts and Travel Speed) and the preheat temperature of 70 degrees F were established and in accordance with WPS-D1.6-F1204 .

After the fillet weld operation was completed on the stainless steel plate to carbon steel of Outrigger Beam West #2, this QA Inspector observed QC Inspector Mr. Bernie Docena perform a visual inspection of the fillet weld to verify the fillet weld size and weld quality. The fillet weld size and quality appeared to be in general compliance with AWS D1.5-2002 and the contract specifications.

**Pier 7 Tower Boom Component: Outrigger Beam East #1**

This QA Inspector randomly observed ABF welder Mr. Jason Collins (Welder ID 8128) performing the fillet weld operation on the stainless steel plate A240 316L plate to A709 Grade 345 of Outrigger Beam East #2 per the Shielded Metal Arc Welding (SMAW) process in the (2F) horizontal position. This QA Inspector observed QC

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Inspector Mr. Bernie Docena verify prior to the start of the fillet weld operation that the welding parameters (Amps, Volts and Travel Speed) and the preheat temperature of 70 degrees F were established and in accordance with WPS-D1.6-F1204.

After the fillet weld operation was completed, this QA Inspector observed QC Inspector Mr. Bernie Docena perform a visual inspection of the fillet weld to verify the fillet weld size and weld quality. The fillet weld size and quality appeared to be in general compliance with AWS D1.5-2002 and the contract specifications.

CCO: 128 - Description: Provide Tower Outrigger Booms in lieu of the Tower Booms in the original Contract plan sheets on the North West (NW) and South East (SE) Tower Legs at approximate Elevation 160.00 M.

### Pier 7 Tower Boom Component: Outrigger Beam West #2

This QA Inspector observed ABF personnel Mr. Jason Collins performing the drill and tap operation - 9.5 diameter ASTM A276 Type 316 countersunk bolts for installation of the UHMW plastic plate to be used as a drilling template for the brass plate on the Tower Boom Component Outrigger Beam West #2. The drill and tap operation was completed on the UHMW plate template and installed until the brass plate arrived at the end of January, 2012.



### Summary of Conversations:

No significant conversations were reportable on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Peterson, Art

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer

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